

Need! Aviz!

Work Order ID 161727

161727

Page 1

Item ID: D3500-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle

Start Date: 6/9/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 6/16/2017 Req'd Qty: 40.00

40

Customer:

Reference:

DAS

21

Approvals:

Process Plan:

2-89

Date:

MAY 23 2017

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3500	C

100

2.84

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

10.19

HAAS CNC vertical machine #1

Program Batch No. 161727 Double check by: 2-22 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets 2-Machine Step
No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA641 and inspect p

40

Ø

DAS

44

9-89

DAS

14

9-89

17-05-30

17/06/01

110

0.00

110

QC

Quality Control

QC2

QC2- Inspection performed by CMM

Memo

0.40

Inspect on CMM as per folio CMM A031.

DWG REV: _____

CMM PROG. REV: _____

40

Ø

DAS

44

9-89

DAS

14

9-89

17-05-30

17/06/01

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.80

40

Ø

DAS

49

9-89

17/06/08

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 161727

Tuesday, May 23, 2017 9:33:15 AM

161727

Page 2

Item ID: D3500-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 6/9/2017 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 6/16/2017 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 2.23				<u>(X40)</u>	<u>Ø</u>	<u>2020224</u> <u>BEB</u>	
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <u>M 138014</u> Memo START TIME: <u>8:15</u> <u>8:00</u> FINISH TIME: <u>8:45</u>	0.00 1.23				<u>40</u>	<u>Ø</u>	<u>17-07-26</u> <u>23 34 38</u>	
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.40				<u>40</u>		<u>40</u> <u>38</u> <u>9-89</u> <u>JUL 26 2017</u>	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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**DAG
21
8-89**

JUL 27 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, May 23, 2017 9:33:14 AM

Page 1

Work Order ID: 161727

161727

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 6/9/2017

Required Date: 6/16/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	11.0000	1	40			
D6102-013									**				
Saddle Billet													

DAS
44
9-89

17-05-30

Location

Loc Qty

Loc Code

MAT046

11

155444

11

11

160144

29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

DART AEROSPACE LTD		Work Order:	161727
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.372	.378	.380	.380	.380
F	0.490	0.510		.500	.500	.500	.500	.497
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.251	.252	.251	.251	.251
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		5.997	5.997	5.998	5.997	5.997
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.549	.549	.549	.548	.549
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.635	.630	.630	.630	.630
AD	0.240	0.260		.249	.248	.250	.249	.249
AE	1.810	1.830		1.820	1.821	1.821	1.821	1.821
AF	0.240	0.260		.249	.250	.249	.248	.249
AG	0.140	0.160		.149	.150	.149	.149	.149
AH	0.140	0.160		.154	.155	.152	.151	.150
AI	0.140	0.160		.152	.153	.153	.153	.153
DAS Accept/Reject				/	/	/	/	/

Measured by:	44 9-89	Date:	17-05-80
Audited by:	49	Date:	17/06/88
Preliminary Approval:	9-89	Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 161727	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	10
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.380	.380	.380	.380	.380
F	0.490	0.510		.498	.500	.499	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.251	.251	.251	.251	.250
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		5.997	5.997	5.997	5.997	5.998
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.548	.549	.549	.548
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.249	.249	.248	.249	.248
AE	1.810	1.830		1.821	1.821	1.820	1.820	1.820
AF	0.240	0.260		.249	.249	.249	.248	.248
AG	0.140	0.160		.149	.148	.150	.149	.149
AH	0.140	0.160		.151	.150	.151	.150	.147
AI	0.140	0.160		.153	.153	.153	.152	.155

DAS Accept/Reject

Measured by: 44	Date: 17-05-31
Audited by: DAS 49	Date: 17/06/08
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order:	161727
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		3.180	3.180	3.180	3.180	3.180
E	0.365	0.385		.378	.378	.378	.378	.378
F	0.490	0.510		.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.249	.249	.250	.249	.250
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.548	.548	.548	.547
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		R.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.105	.105	.105	.105	.105
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.247	.247	.247	.247	.246
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.140	0.160		.149	.149	.149	.149	.149
AH	0.140	0.160		.146	.146	.147	.146	.147
AI	0.140	0.160		.153	.156	.156	.152	.152

Accept/Reject

Measured by:	<i>ML</i> 14 9-89	DAS	Date:	17/06/01
Audited by:		49 9-89	Date:	17/06/08
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	161727
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.380	.380	.380	.380	.380
F	0.490	0.510		.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.249	.250	.249	.250	.248
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.546	.548	.548	.547
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.246	.247	.247	.247	.246
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.817
AF	0.240	0.260		.249	.249	.249	.249	.249
AG	0.140	0.160		.149	.149	.149	.149	.149
AH	0.140	0.160		.147	.147	.146	.146	.146
AI	0.140	0.160		.151	.150	.149	.150	.151

Accept/Rejects

Measured by:	<i>OMK</i>	14	Date:	17/04/01
Audited by:		DAS	Date:	12/06/08
Preliminary Approval:		49	Date:	
		9-89		

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 161727	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21	22	23	24	25
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.380	.380	.380	.380	.380
F	0.490	0.510		.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.250	.250	.250	.250	.249
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.998	5.998	5.998	5.998	5.998
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.546	.547	.546	.546	.547
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.247	.248	.247	.247	.249
AE	1.810	1.830		1.820	1.821	1.821	1.820	1.821
AF	0.240	0.260		.249	.249	.249	.250	.250
AG	0.140	0.160		.149	.149	.149	.150	.150
AH	0.140	0.160		.149	.147	.147	.147	.147
AI	0.140	0.160		.151	.151	.150	.150	.150

Accept/Reject

Measured by: <i>gnk</i>	Date: 17/06/01
Audited by: <i>9-89</i>	Date: 17/06/08
Preliminary Approval: <i>49</i>	Date: <i>9-89</i>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ <i>gnk</i>	<i>gnk</i>

DART AEROSPACE LTD				Work Order: 161727	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				26	27	28	29	30
A	0.483	0.490		.486	.486	.486	.486	.486
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.380	.380	.380	.380	.380
F	0.490	0.510		.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.250	.250	.250	.250	.250
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		5.998	5.998	5.998	5.998	5.998
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.547	.547	.547	.548	.548
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.247	.246	.246	.246	.246
AE	1.810	1.830		1.821	1.821	1.821	1.821	1.821
AF	0.240	0.260		.249	.250	.250	.250	.250
AG	0.140	0.160		.150	.150	.150	.150	.150
AH	0.140	0.160		.147	.146	.146	.147	.147
AI	0.140	0.160		.151	.152	.152	.152	.152

DAS accept/Reject

Measured by: 14 9-88 DAS	Date: 17/06/02
Audited by: 49	Date: 17/06/08
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order:	16727
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				31	32	33	34	35
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.380	.380	.380	.380	.380
F	0.490	0.510		.499	.498	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.251	.251	.251	.251	.252
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		5.997	5.997	5.997	5.997	5.997
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.550	.549	.549	.549
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.250	.248	.249	.249	.249
AE	1.810	1.830		1.821	1.821	1.822	1.821	1.821
AF	0.240	0.260		.250	.250	.250	.250	.249
AG	0.140	0.160		.150	.150	.150	.149	.149
AH	0.140	0.160		.150	.148	.150	.150	.150
AI	0.140	0.160		.155	.154	.154	.155	.155
Accept/Reject				✓	✓	✓	✓	✓

Measured by:	<i>mk / f.k.</i>	DAS	Date:	17/06/02
Audited by:		49	Date:	17/06/08
Preliminary Approval:		9-89	Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 161727
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				36	37	38	39	40
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.380	.380	.380	.380	.380
F	0.490	0.510		.500	.500	.499	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.251	.251	.251	.251	.251
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		5.997	5.997	5.997	5.997	5.997
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.549	.549	.549	.549	.549
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.248	.249	.249	.248	.249
AE	1.810	1.830		1.821	1.821	1.821	1.821	1.821
AF	0.240	0.260		.250	.250	.249	.249	.249
AG	0.140	0.160		.150	.149	.149	.149	.150
AH	0.140	0.160		.151	.149	.151	.150	.151
AI	0.140	0.160		.153	.154	.153	.153	.155

DAS Accept/Reject

Measured by: 44	DAS	Date: 17-06-03
Audited by: 49	9-89	Date: 17/06/04
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

